

Date: Thursday, 05/02/2009 3:47:30 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 45570		
Estimate Number	: 12704		
P.O. Number	:	Part Number	: D35501
This Issue	: 05/02/2009 S.O. No. :	Drawing Number	: D3550 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 36226	Material	:
Written By	:	Due Date	: 20/02/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>JUD 09.02.04</u>		
Comment	: Est. A 07.02.05 New issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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Comment: Qty.: 1.7850 f(s)/Unit Total: ~~17.8500~~ f(s) 18.500  
 304 RD Tube .500 x .049W  
 304/316 Seamless tubing, 1/2" OD x .049 Wall

Batch M108828

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 1-Form per Dwg D3550 using DT 8012

83 09/02/19

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1-form other end of strut at 1.8" using DT 8984  
 2-Deburr if necessary.

M-1

88 09/02/24 10x  
09/02/24

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5 09/02/24 x10

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 8:00am

OVEN TEMPERATURE: 400°F

FINISH TIME: 8:30am

94

09-02-25

x10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 05/02/2009 3:47:31 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 45570

Part Number: D35501

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10  
BK 09-02-25

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST271

SS 09/02/25 R6

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26 JJ

Job Completion



W09.02.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

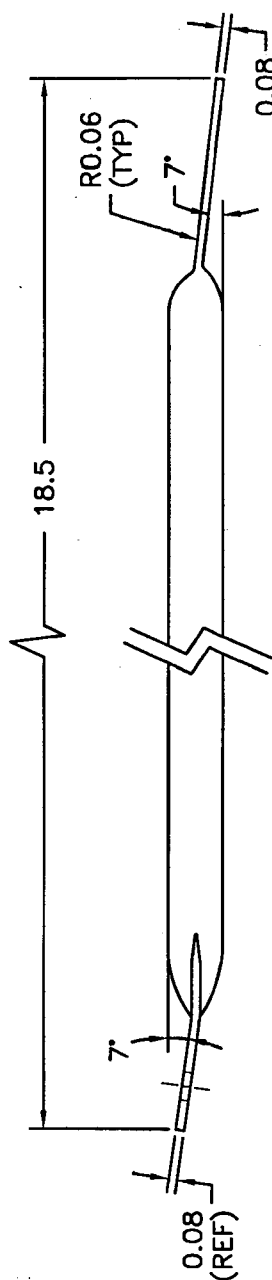
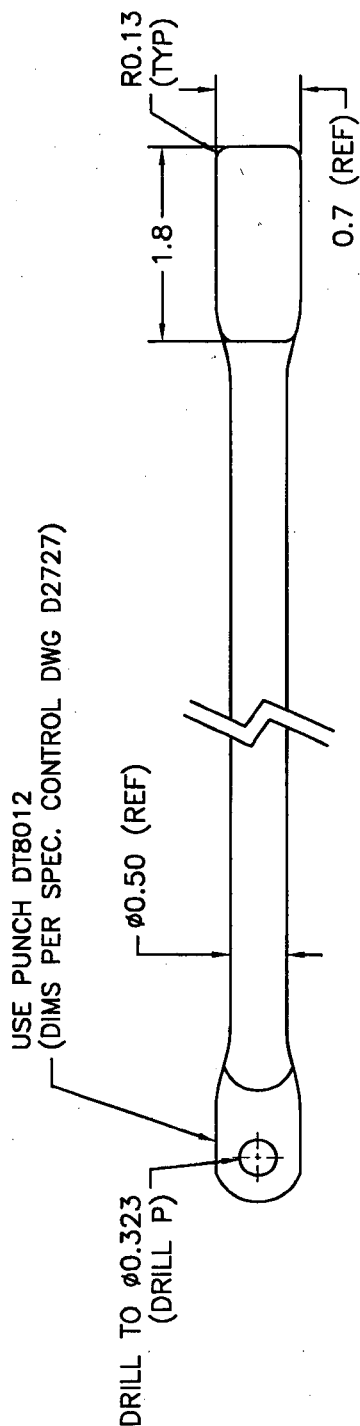
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

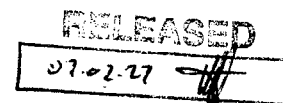
**NOTE:** Date & initial all entries

**DART**

DESIGN <b>LE</b>	DRAWN BY <b>LE</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>PH</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D3550	REV. B SHEET 1 OF 1
DATE 07.02.13		TITLE STRUT	SCALE NTS
A	06.10.24	NEW ISSUE	
B	07.02.13	18.5 WAS 20.13; 1.8 WAS 1.5	

**D3550-1 STRUT**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **45570**

**NOTES:**

- 1) MATERIAL: 304/316 SS SEAMLESS ROUND TUBE 0.500 OD X 0.049 WALL  
(REF DART SPEC M304.TR0.500W.049)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3550-1 USING FINE POINT PERMANENT INK MARKER

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